



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

Tel (613) 632-5200

D3674-043
Job Sheet 169355



Part No: D3674-043

Job Qty: 4 ea

Part Name: Roller Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/8/17

Job Tracking No:

Due Date: 1/4/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV B IPP Rev: A RQ. 16.07.11 Verified by DD.

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		1/3/18	0.00	0.00	Start Up Machining-2		<i>dd</i> 18-01-29
100	Bandsaw	4 pcs		1/3/18	0.00	0.15	Bandsaw1		<i>dd</i> 18-01-29
110	CNC Vertical Machining	4 pcs		1/3/18	1.49	10.26	HAAS 5 Axis		<i>dd</i> 18-01-29
120	QC	4 pcs		1/3/18	0.00	0.00	QC2 Machining-2		<i>dd</i> 18-01-29
130	QC	4 pcs		1/3/18	0.00	0.00	QC8 Machining-2		<i>dd</i> 18/01/31
140	Small Fab	4 pcs		1/4/18	0.00	0.12	Small Fab-4		<i>DD</i> DAS 38
150	QC	4 pcs		1/4/18	0.00	0.00	QC5		<i>DD</i> 9-88
160	Packaging	4 pcs		1/4/18	0.00	0.00	Packaging3-1		
170	QC21-SA	4 Ea		1/4/18	0.00	0.00	QC21		

Part Op 100 - Cut blanks: (1.500" x 2.250") 5.600" long

Descriptions: 110 - 1-Machine D3674-3 as per Folio Fb483 and Dwg D3674-3.

140 - Assemble D3674-043 as per Dwg D3674.

DAS
21
9-88

FEB 06 2018

FEB 07 2018

SJL 57048

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-B1.500X02.250	2	17	0	0
140-Small Fab	D3121-21 <i>3037655 8x</i>	8	50	0	0
	D3183-045 <i>F165745 2x</i>	8	23	0	0
	<i>5021366 4x</i> <i>5011283 2x</i>				

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S036281



Roller Bracket Assembly

PART NO: D3674-043
Original Serial #: S036281
Revision:
Operation:
Change No:

Start up Operation 01/29/18

Job No: 169355

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DART AEROSPACE LTD		Work Order:	169 355
Description: Roller Bracket Assembly		Part Number:	D3674-043
Inspection Dwg: D3674	Rev: B	Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.162	+/-0.010	.161	✓		SL10	Vern
4.26	+/-0.030	4.260	✓			
1.89	+/-0.030	1.888	✓			
1.16	+/-0.030	1.160	✓			
2.08	+/-0.030	2.080	✓			
0.36	+/-0.030	.360	✓			
R0.25	+/-0.030	.250	✓		Rad gauge	
R0.19	+/-0.030	.190	✓			
R0.19	+/-0.030	.190	✓			
R0.25	+/-0.030	.250	✓			
R0.13	+/-0.030	.130	✓			
Ø0.392	+0.002/-0.000	.3933	✓		SL02	Mic
R0.29	+/-0.030	.290	✓		Rad gauge	
R0.50	+/-0.030	.500	✓		"	
3.954	+/-0.010	3.955	✓		Height gauge	
0.162	+/-0.010	.161	✓		SL10	Vern
0.995	+/-0.010	.997	✓			
Ø0.201 x 0.100 DP	+0.005/-0.001 x +/-0.010	.201 X .096	✓			
1.18	+/-0.030	1.180	✓			
0.10	+/-0.030	.100	✓			
5.323	+/-0.010	5.328	✓			
5.036	+/-0.010	5.036	✓			
2.49	+/-0.030	2.494	✓			
2.385	+/-0.010	2.393	✓			
1.555	+/-0.010	1.553	✓			
0.265	+/-0.010	.263	✓			
13°	+/-0.5°	13°	✓		Protractor	
11°	+/-0.5°	11°	✓		"	
0.795	+/-0.010	.800	✓		SL10	Vern
R0.25	+/-0.030	.250	✓		Rad gauge	
R0.19	+/-0.030	.190	✓		"	
0.182	+/-0.010	.182	✓		SL10	Vern
0.020 x 30°	+/-0.010 x +/-0.5°	.015 X 30°	✓			
0.170	+/-0.010	.167	✓			
0.07 x 45°	+/-0.030 x +/-0.5°	.073 X 45°	✓			
0.741	+/-0.010	.741	✓			
4.8°	+/-0.5°	4.8°	✓			
R0.06	+/-0.030	.060	✓		Rad gauge	
0.032	+/-0.010	.031	✓		SL10	Vern

